GREEN

Dart Aerospace Ltd.

[redacted]rsday, 22/01/2009 7:56:38 AM
Use[redacted] Melanie Lauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: UPPER RESTRAINT WELDMENT
Job Number	: 45031		
Estimate Number	: 13398		
P.O. Number	:	**Part Number**	: PB674300131
This Issue	: 22/01/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.41/ P.43
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: B1
Previous Run	: 41377	**Material**	:
Written By	:	**Due Date**	: 28/01/2009 **Qty:** 5 **Um:** Each
Checked & Approved By	: MF 09-01-22		
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet

Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s)
6061-T6 .090 Sheet
batch: 109184 HB 9-2-5

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001-321
Dwg Rev: B1 HB 9-2-5
Prog Rev: B1
***grain direction along 25.00" ***
2-Deburr if necessary HB 9-2-5

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-2-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

S 02/02/05 (6)

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE

PTO

Comment: NC BRAKE
Bend as per Dwg B67-43001

HB 09/02/12 (5)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: PB67-43001 - 31 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** S **Date:** 09/04/05

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR: 45031		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
09/02/12	5	1 piece scrap because Tolerance change add .100" More on side R.C. Drawing change.	[signature]	Scrap & destroy No replace.	CB 09/02/12	[signature] 09-02-12	[signature] 09/02/12	[signature] 09-02-12

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:56:38 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** UPPER RESTRAINT WELDMENT

Job Number: 45031 **Part Number:** PB674300131

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP S 09/02/12 (x5)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 09-02-12 (X5)

8.0	POWDER COATING	POWDER COATING

M102316 (5X)

Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 11:20
OVEN TEMPERATURE: 320 °F
FINISH TIME: 11:50

M-L 09/02/14

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION FL 09/04/06 (5)

10.0	PB674300133	Upper Pad Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Upper Pad Assembly
batch: 541505. FL

11.0	NAS1149F0316P	WASHER

Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)
WASHER
batch: m111124 FL

12.0	MS27039109	Screw

Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)
Screw
batch: ~~M107376~~ m18057 (x20) * m18106(x5) FL 09/04/06 (5) (RO)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
09/04/06	12.0	Change screw MS270391-09 for screw MS270391-07.	FL	09/04/06	25		

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:56:39 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** UPPER RESTRAINT WELDMENT

Job Number: 45031 **Part Number:** PB674300131

Job Number:

Seq. #:	Machine Or Operation:	Description :	
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	(5) FL 09/04/06
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per dwg B67-43001		
14.0	QC5	INSPECT WORK TO CURRENT STEP	09-04-07 (5)
	Comment: INSPECT WORK TO CURRENT STEP		
15.0	PACKAGING 1	PACKAGING RESOURCE #1	(SC) SC
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 443	9/4/7	
16.0	QC21	FINAL INSPECTION/W/O RELEASE	09/04/07
	Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion MF 09-04-07

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

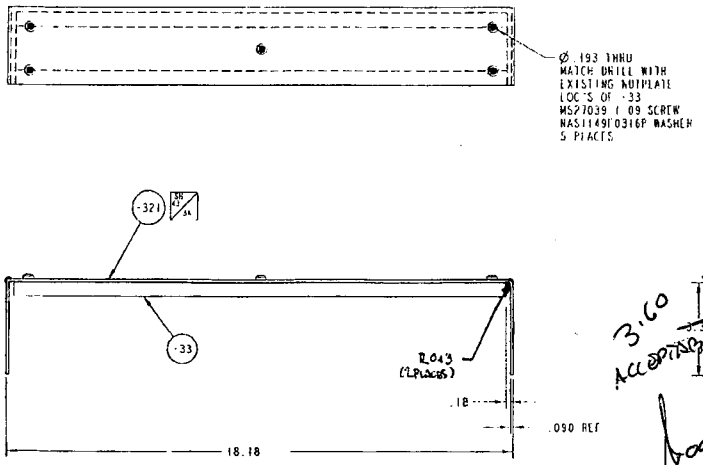
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

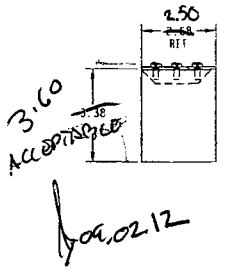
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

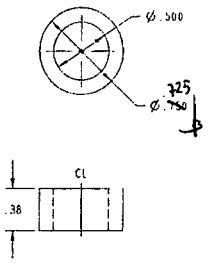
NOTE: Date & initial all entries

RELEASED
dt. 01.20

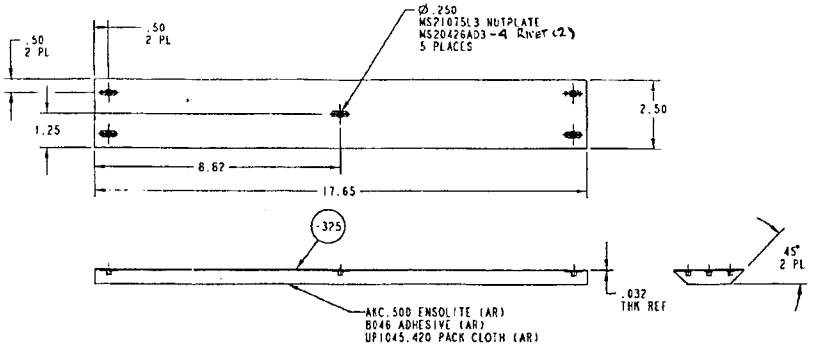


1 -31 UPPER RESTRAINT WELDMENT
SCALE 0.500

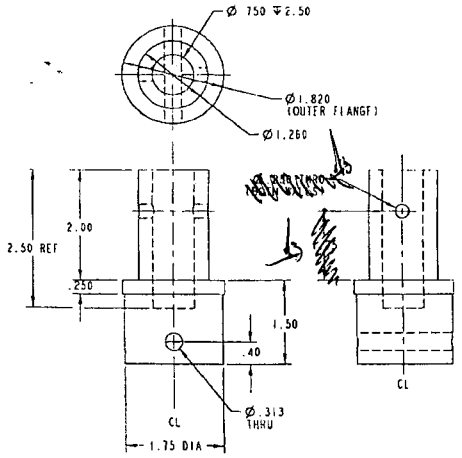




4 -299 BUSHING
SCALE 2.000
MAT: 304 CRES, COND A



1 -33 UPPER PAD ASSY
SCALE 0.500
MATL FOR -325: .032 THK 2024-T3 AL,
QQ-A-250/4



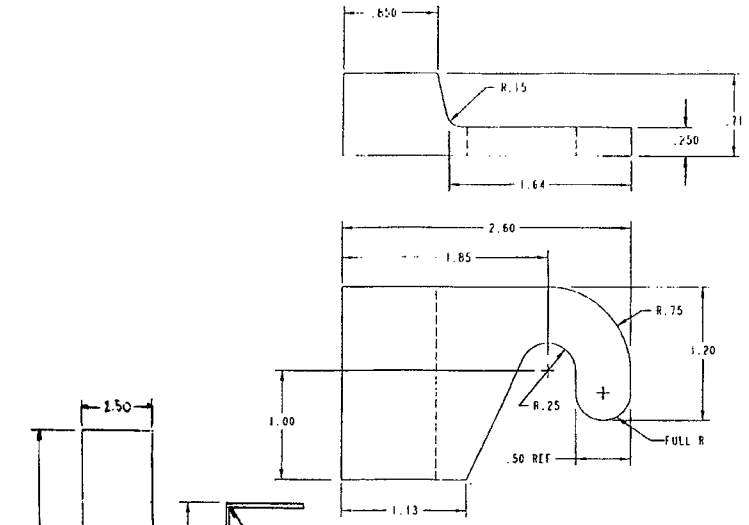
45031

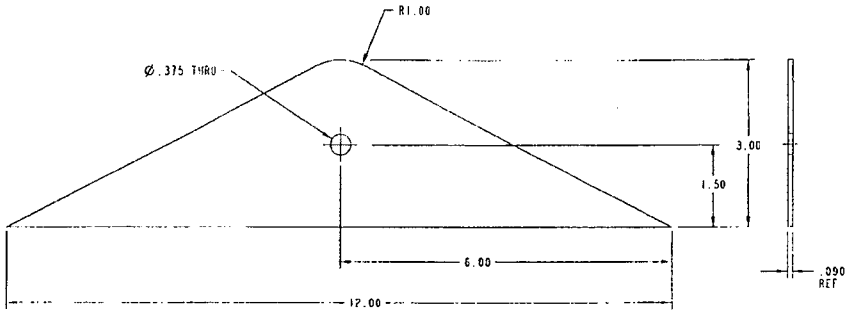
1 -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
QQ-A-200/3
JLM

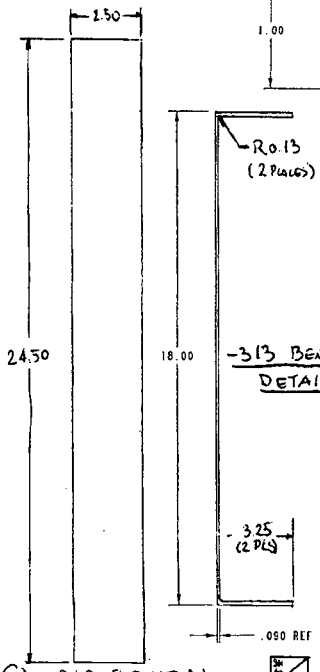
PREMIER AVIATION, INC.
2601 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CODE IDENT NO.	DWG NO.	REV
D	05UV8	B67-43001	B1
SCALE:	WT:	SHEET 41 OF 45	

ORIGINAL







(1) -313 FLAT PATTERN
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

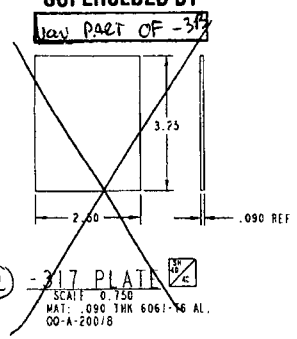
(3) -315 HOOK
SCALE 2.000
MAT: 6061-T6 AL.
QQ-A-200/8

JH

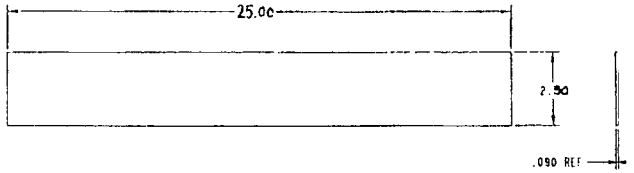
(2) -319 GUSSET
SCALE 1.000
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

45031

SUPERCEDED BY
New PART OF -317



(2) -317 PLATE
SCALE 0.750
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8



(1) -321 PLATE
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
QQ-A-200/8

RELEASED
04-01-20

PREMIER AVIATION, INC.
2601 Aviation Parkway, Grand Prairie, Texas 75052

D	05UV8	D67-43001	E
SCALE	WT.	SHEET 43 OF 45	

ORIGINAL

DART AEROSPACE LTD	Work Order:	W5003
Description: Upper Restraint Weldment	Part Number:	B67-43001-321
Inspection Dwg: B67-43001 Pg43,41 **Rev:** B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.193	+0.005/-0.001	.197	✓			
2.50	+/-0.030	2.501	✓			
25.00	+/-0.030	25.00	✓			

Measured by:	RB
Date:	9-2-5

Audited by:	S
Date:	09/02/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change		Revised by	Approved
A	08.10.10	New Issue	P/O B67-43001-31	KJ/DD	